

Work Order ID 100063

Invi-13 1.07:56 PM

100063

Page 1

Item ID: D4004-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Side Restraint Angle

Stop

NS2

Start Date: 4/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 13-04-17 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4004	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4004-1) Dwg Rev: <u>B</u> Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

4

(DAS)
05 13-04-21

4

(DAS)
05 13-04-21

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/>	
										<input type="checkbox"/> Other	

Work Order ID 100063

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100063

Page 2

Item ID: D4004-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Side Restraint Angle

Stop

NS2

Start Date: 4/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC8- Inspect parts - second check Quality Control	0.00 0.00	DAS 16 3/8/22			40			

130 *130* Brake NC	Bend as per dwg Brake NC	0.00							S 13/04/22
	Memo 1- Bend D4004-1 as per Dwg 2- C'sink as per dwg	0.00							J S, 13/04/22

140 *140* QC	QC5- Inspect part completeness to step on W/O Quality Control	0.00 0.00	DAS 16 3/8/22			40			
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NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No.:											
NCR No.:											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

Work Order ID 100063

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100063

Page 3

Item ID: D4004-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Side Restraint Angle

Stop

NS2

Start Date: 4/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Hand Finishing

4 16/13/403

155

QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Quality Control

H 4/13/424

160

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

7-40

0.00

Start Time:

320°F

Oven Temperature:

Finish Time:

8-10

*4X 4/13/04/26**m118533*

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled

Work Order ID 100063

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100063

Page 4

Item ID: D4004-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Side Restraint Angle

Stop

NS2

Start Date: 4/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC3- Inspect Part Finish

0.00

4 x d 11 13/04/2013

170

QC

Quality Control

Memo

0.00

180

180

Small Fab

Memo

0.00

13-05-01

Small Fab

Assemble as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00

4/13/13

190

QC

Quality Control

Memo

0.00

B501

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	Other		

Work Order ID 100063

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Page 5

Item ID: D4004-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Side Restraint Angle

Stop

NS2

Start Date: 4/17/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Packaging	Identify as per dwg & Stock Location: <i>ST 243A</i>	0.00							<i>4/13/13, G</i>
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release <i>ST 243A</i>	0.00							<i>13/5/13, J</i>
									<i>U 13-050</i>

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No.											
NCR No.											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
			Bending	Bend	Grain	Ovalized	Pressure/Forced				
			Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure				
			Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld				
			Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled				
			Cuffs	Contamination	Maintenance	Part Moved					
			Heat Treat	Countersink	Mislabeled	Positioned Wrong					
			Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge					
			Ripples in Bend	Drill Holes	Offset						
			Torque Waves in Extrusion	Drawing	Out of Calibration						
			Turning Sequence	Finish	Out of Sequence						
			Wave/Twist in Tube	Folio	Outside Dimensions						

PICKLIST PRINT

April 17, 13 10:08:00 PM

Page 1

Work Order ID: 100063

100063

Parent Item: D4004-041

D4004-041

Parent Item Name: Side Restraint Angle

Start Date: 4/17/13

Required Date: 5/01/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf: IPP Rev:C 12.03.07 as
per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063		Purchased	No			100	sf	125.8800	0.22	0.926316			
--------------	--	-----------	----	--	--	-----	----	----------	------	----------	--	--	--

M2024T3S 063

2024-T3 .063 sheet

W 13-04-21

Location	Loc Qty	Loc Code
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MAT022	125.88	
119916	0.2	
121197	21.34	
123096	11.4	
123654	11.64	
<u>123701</u>	81.3	

D4004-3

Manufactured No

180 Each 0.0000 1 4

D4004-3

Strut Lock Bracket

B 95845 4

SB 10/01/01

D4004-7

Manufactured No

180 Each 31.0000 1 4

D4004-7

Hose Clip

**

FF 13-05-01

Location	Loc Qty	Loc Code
----------	---------	----------

GA	31	
79992	1	
<u>85482</u>	30	

MS20426AD4-4

Purchased No

180 Each 591.0000 1 4

MS20426AD4-4

Rivet

**

FF 13-05-01

Location	Loc Qty	Loc Code
----------	---------	----------

GA	591	
<u>121090</u>	591	

4

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Part No. _____	NCR No. _____												
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

Picklist Print

April-17-13 1:08:00 PM

Page 2

Work Order ID: 100063

Parent Item: D4004-041

Parent Item Name: Side Restraint Angle

100063
D4004-041

Start Date: 4/17/13

Required Date: 5/01/13

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-5

Purchased

No

180

Each

1,643.000

2

8

*********MS20426AD4-5***

Rivet

FF 13~05~01

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA 6874	13 13	8
ST317 6874	1630 1630	_____

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

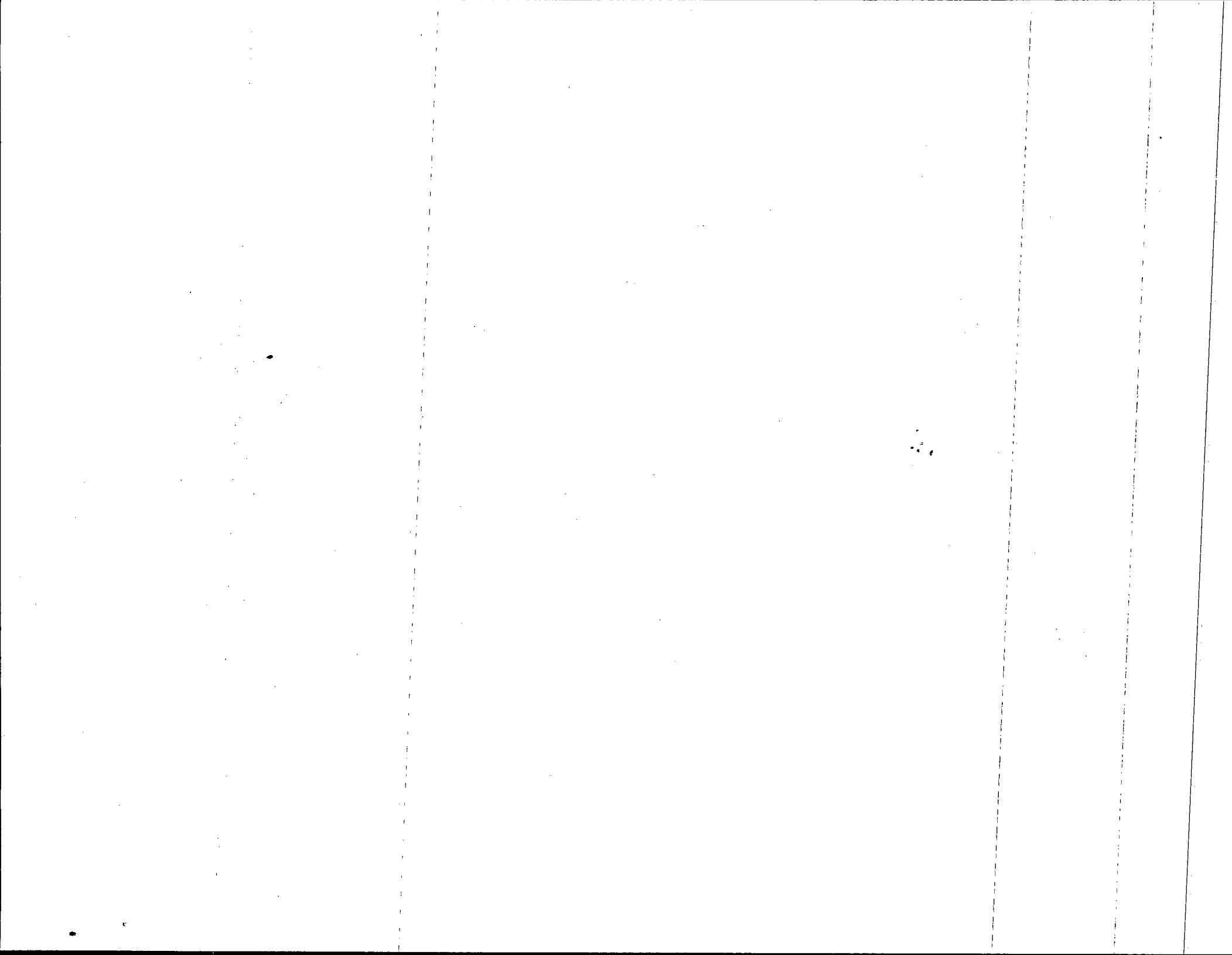
Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No.	NCR No.										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							

DART AEROSPACE LTD	Work Order:	100063
Description: Side Restraint	Part Number:	D4004-1
Inspection Dwg: D4004 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>M. M.</i>	Audited by:	<i>JAS</i>	Preliminary Approval:	
Date:	13.04.21	Date:	16 9.55	13/04/21	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue P/O D4004-041	KJ	
B	13.02.27	Dwg Rev updated	KJ	



ITEM NO	QTY	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	4	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	ANGLE	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	

SP-1
K-2970

ENCLOSURE

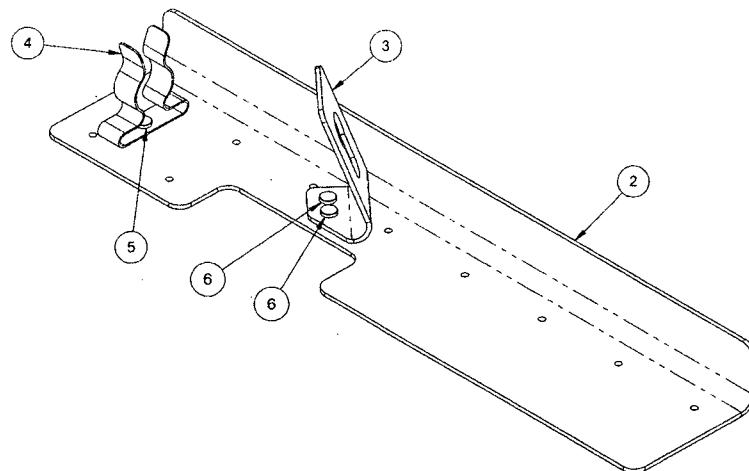
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

W/LM - OFFICE

WORK ORDER

NU_100063_MUJ

1304-17



D4004-041 SIDE RESTRAINT ANGLE

B	CHANGE POWDER COAT FROM "GREY SANTEX" TO "ANSI 61 GREY", ZN A8-1, ZN A8-2.	DC	12.02.27
A	NEW ISSUE	HS	10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>CE</i>	D4004	SHEET 1 OF 11
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	SIDE RESTRAINT	NTS
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

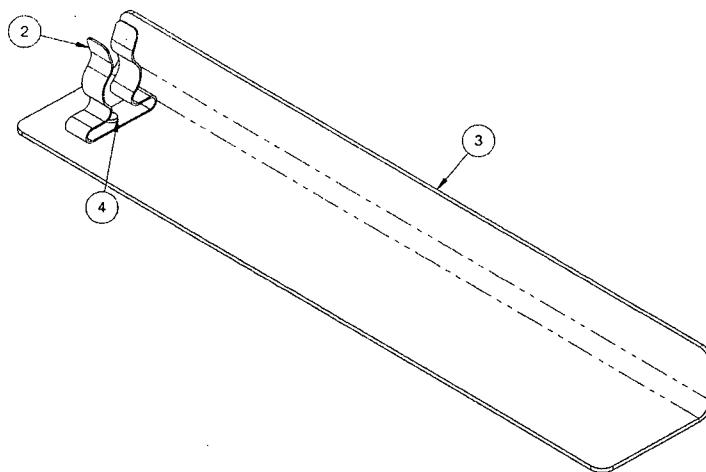
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3 B
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

8 7 6 5 4 3 2 1

100063

ITEM NO	QTY	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
	X	D4004-043	SIDE RESTRAINT ANGLE AND TIE DOWN POINT	JCA-M47-2-04
2	1	D4004-7	HOSE CLIP	
3	1	D404-1-9	ANGLE	
4	1	MS20426AD4	RIVET	



D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT

RELEASED
2012-03-02
NM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

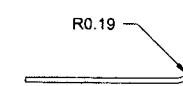
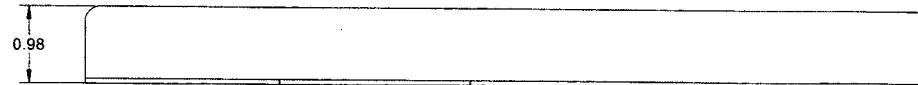
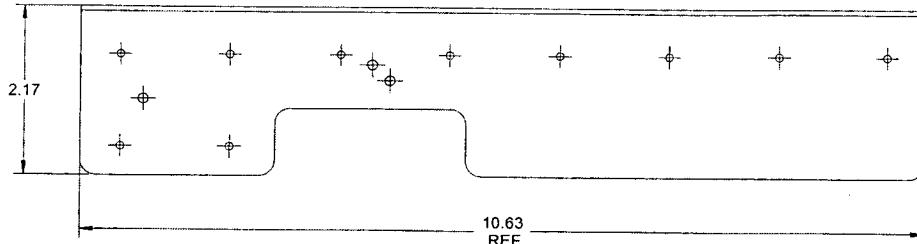
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO. D4004 SHEET 2 OF 11	
APPROVED		TITLE SIDE RESTRAINT	
DE APPR.		SCALE NTS	
DATE	12.02.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

DART AEROSPACE
PART NUMBER
D4004-1

JOHN CAMERON AVIATION
PART NUMBER
EFU.CAM172.19

100063



D4004-1 SIDE RESTRAINT

NOTES:

- 1) MATERIAL: MADE FROM D4004-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

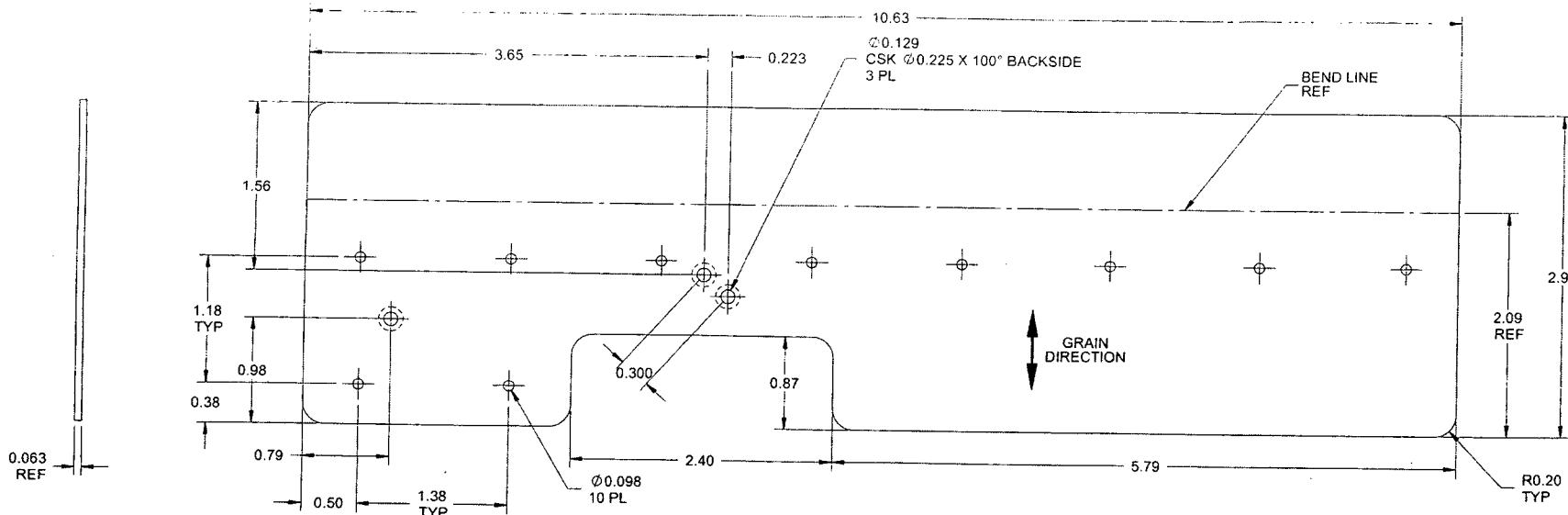
8 7 6 5 4 3 2 1

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>JL</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	REV. B
MFG. APPR.	<i>AB</i>	D4004 SHEET 3 OF 11
APPROVED	<i>AB</i>	TITLE
DE APPR.	<i>AB</i>	SIDE RESTRAINT SCALE
DATE	12.02.27	NTS

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RELEASED
2012-03-02
JMP

100063

D4004-1F FLAT PATTERN

RELEASED
2012-03-02
JNP

NOTES:

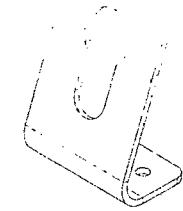
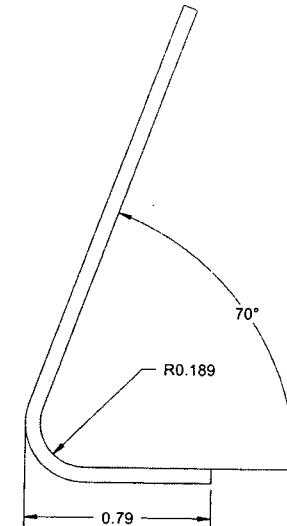
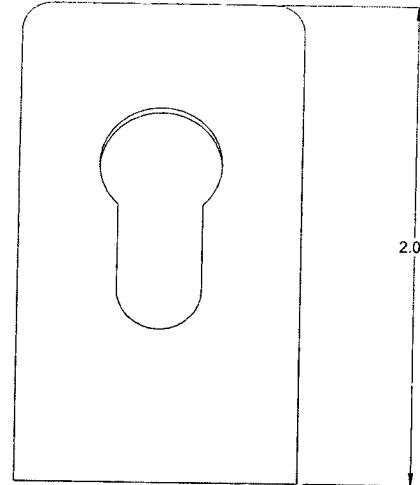
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>JC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO.
MFG. APPR.	<i>PZ</i>	REV. B
APPROVED	<i>AB</i>	D4004
DE APPR.	<i>AB</i>	SHEET 4 OF 11
DATE	12.02.27	TITLE
		SCALE
		NTS
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DART AEROSPACE
PART NUMBER
REF ID: A.M.07.2.16

JOHN CAMERON AVIATION
PART NUMBER

100063



D4004-3 STRUT LOCK BRACKET

RELEASED BY
2012-03-02
MP

NOTES:

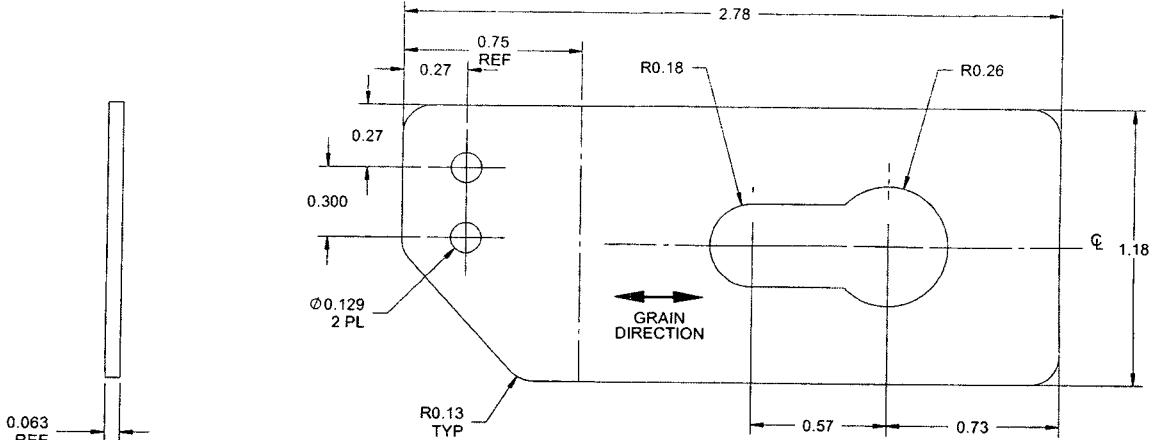
- 1) MATERIAL: MADE FROM D4004-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

DESIGN	AS	DART AEROSPACE LTD
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA
CHECKED	AS	DRAWING NO.
MFG. APPR.	PE	D4004
APPROVED	MP	REV. B
DE APPR.	#	SHEET 5 OF 11
DATE	12.02.27	SCALE
		NTS
		TITLE
		SIDE RESTRAINT

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D4004-3F FLAT PATTERN

NOTES:
 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
 PER QQ-A-250/4 OR AMS-QQ-A-250/4
 OR AMS 4037 OR ASTM B209
 REF DART SPEC M2024T3S.063

2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.02 lbs

8 1 7 1 6 1 5 1 4 1 3 1 2 1

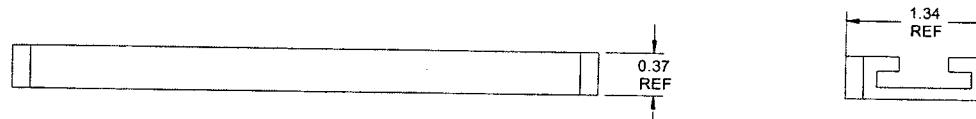
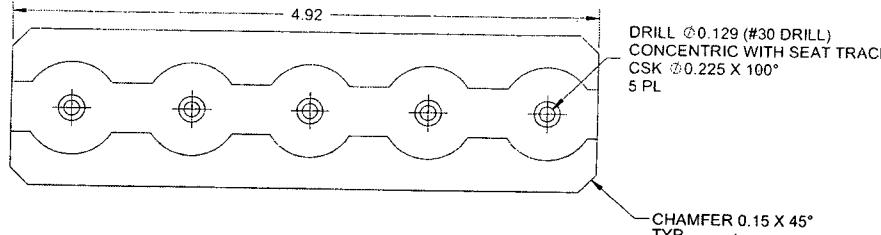
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	REV. B
MFG. APPR.	<i>[Signature]</i>	D4004
APPROVED	<i>[Signature]</i>	SHEET 6 OF 11
DE APPR.	<i>[Signature]</i>	TITLE
DATE	12.02.27	SCALE
		NTS
		SIDE RESTRAINT
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RELEASED
2012-03-02
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DART AEROSPACE
PART NUMBER?

JOHN CAMERON AVIATION
PART NUMBER?

100063



D4004-5 BOTTOM STRAP ATTACH BRACKET

RELEASER
2012-03-01
M

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLINER P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

8 7 6 5 4 3 2 1

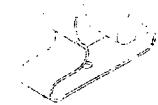
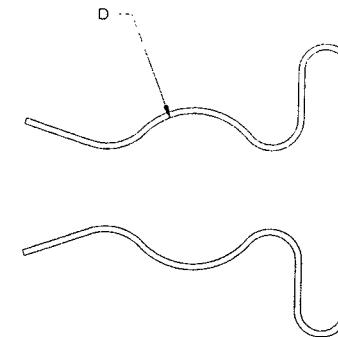
DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>PC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>EB</i>	REV. B
APPROVED	<i>AB</i>	D4004
DE APPR.	<i>AB</i>	SHEET 7 OF 11
DATE	12.02.27	TITLE
		SCALE
		NTS
		SIDE RESTRAINT

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DART AEROSPACE
PART NUMBERJOHN CAMPBELL AVIATION
PART NUMBER

100063

D4004-X

REV. B
REVISIONS: 2012-03-01SPECIFICATION CONTROL DRAWING

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS TUBE Ø "D"	WIDTH "W"
D4004-7	MCMASTER-CARR	1722A42	NICKEL PLATED STEEL	0.31 - 0.75	0.38

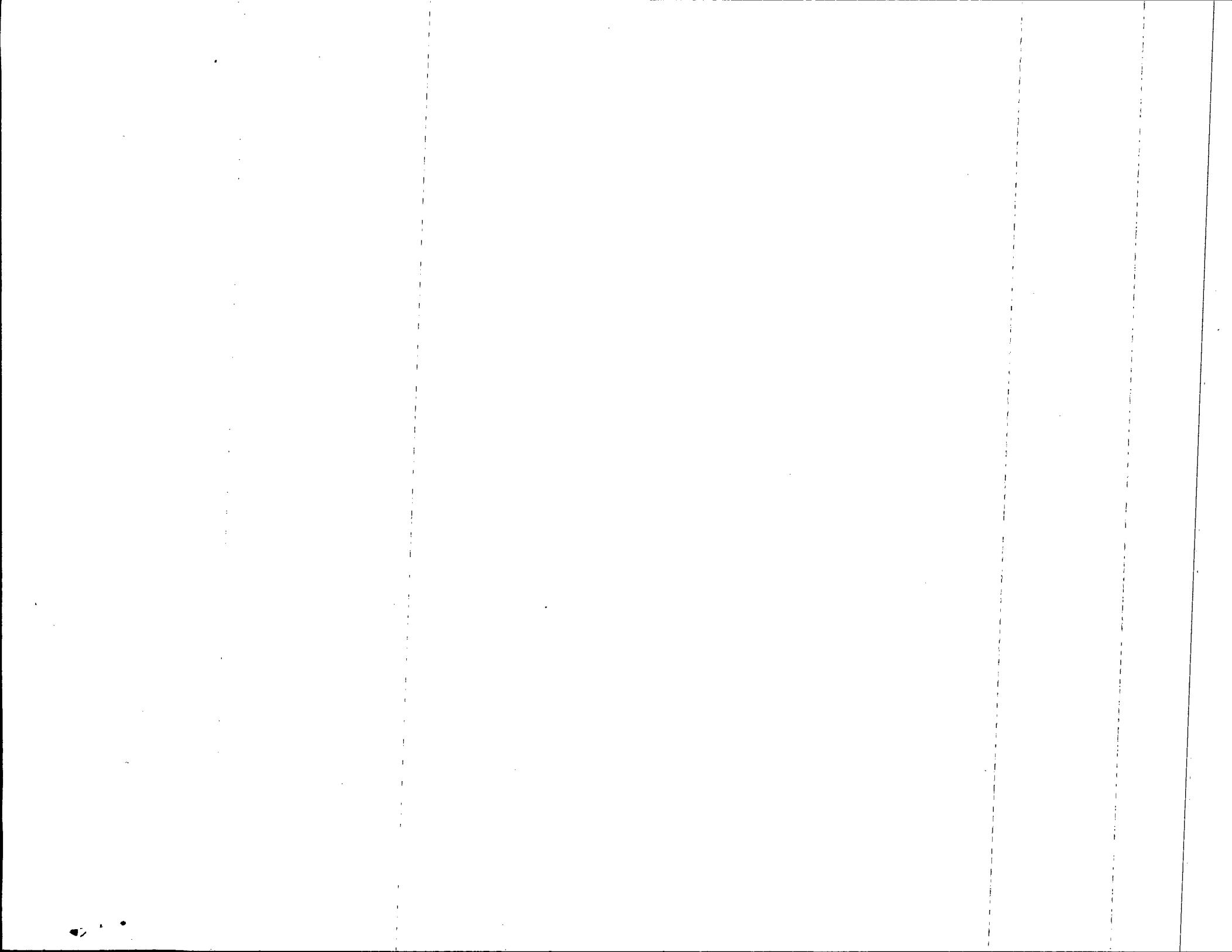
D4004-X HOSE CLIPNOTES:
1) MATERIAL: SEE TABLE
2) FINISH: N/A

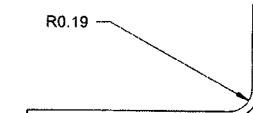
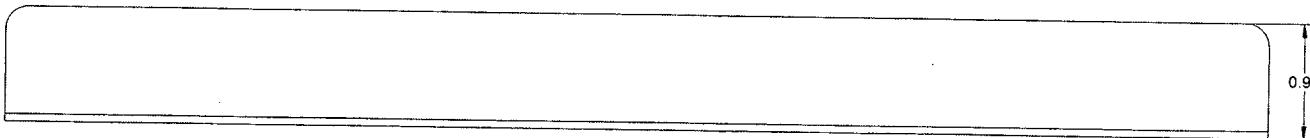
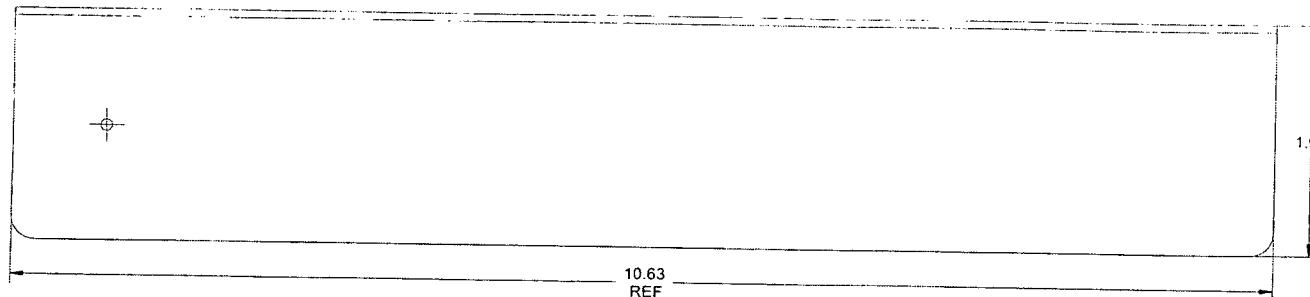
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>JSC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>EZ</i>	REV. B
APPROVED	<i>AB</i>	D4004
DE APPR.	<i>AB</i>	SHEET 8 OF 11
DATE	12.02.27	TITLE
		SIDE RESTRAINT
		SCALE
		NTS

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D4004-9 ANGLE

NOTES:

- 1) MATERIAL: MADE FROM D4004-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

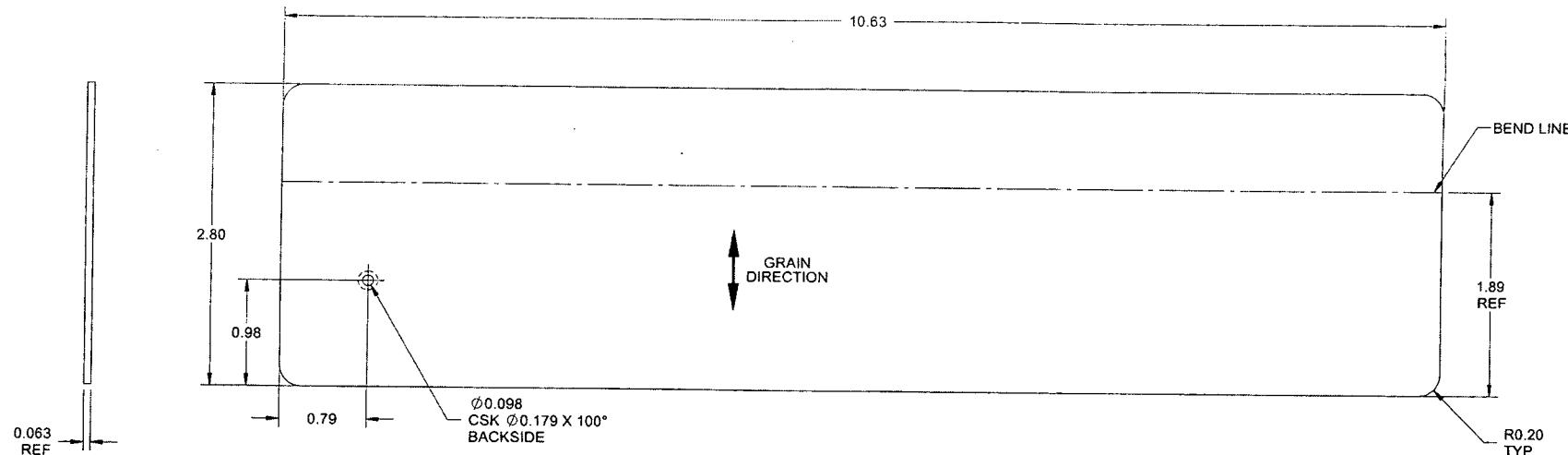
8 7 6 5 4 3 2 1

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BE</i>	DRAWING NO.
MFG. APPR.	<i>BE</i>	REV. B
APPROVED	<i>MF</i>	SHEET 9 OF 11
DE APPR.	<i>MF</i>	TITLE
DATE	12.02.27	SCALE
		NTS

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DD 2012-03-01
[Signature]

100063

D4004-9F FLAT PATTERN

RELEASED
2012-03-01
A

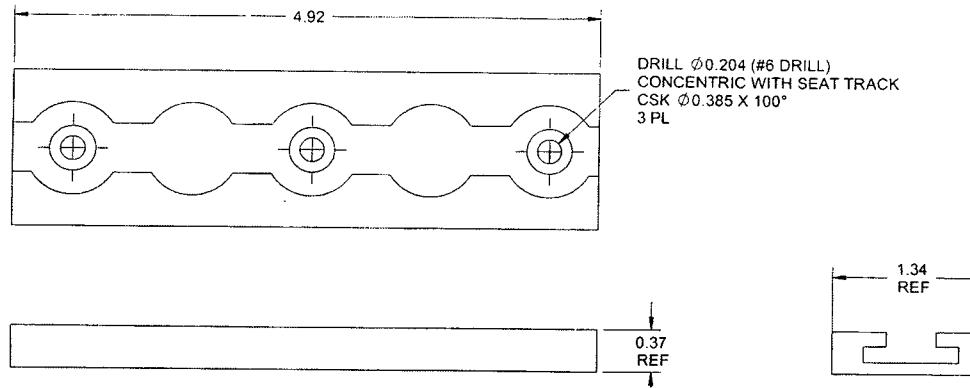
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>SC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO.
MFG. APPR.	<i>BE</i>	REV. B
APPROVED	<i>AB</i>	D4004
DE APPR.	<i>SH</i>	SHEET 10 OF 11
DATE	12.02.27	TITLE SCALE NTS SIDE RESTRAINT

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D4004-11 TOP STRAP ATTACH BRACKET

RELEASED
2012-03-01

NOTES:
1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLINE P/N 20276-144-0-0
OR D3033-144

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>BC</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BC</i>	D4004	SHEET 11 OF 11
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	SIDE RESTRAINT	NTS
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